Work Order ID 108842

B108842

108842

Page 1

October-29-13 1	0:09:15 AM	B108842	100	104/						r age 1
Revision ID:	D2053	. 222	Accept	*N900	040	100)*	Setup Star	1 7	S1*
	Bracket 10/29/13	0 *5*	¥16 *	Cust Item I Customer:	ID:				^N	S2*
Approvals:	Process Plan: MLゴ	Date: 13-10-	So Tooling:	D.	ate:			Run Star	1/1	R1*
	QC:			D	ate:			Stop	*N	R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D2053	Rev C									
100	FLOW WATER JET	Γ	0.00				16	_ပ_		Ae
Waterjet FLOW CNC Waterje	Dwg Ro Prog Ro ****gra	s per Dwg D2053 ev: ev: ain direction along 1.987" ** rr if necessary	0.00							/3 11 18
110	QC2- Inspect parts of	off machine FAI/FAIB	0.00							
110 QC Quality Control	Memo		0.00				16			Az. 13.11.18

DQA:		- Date:			MODE ORDER MON	~			DATE					
QA Closed:		Date:			WORK ORDER NON	-C(JINFOI	RIVIAINCE / UF	PDATE	W	ork Order up	date only		AEROSPACE
					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
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raitiv					Use-as-is	1	i .	noforming	Finishing	⊢	1	e/Packaging	\dashv	Other
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•	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	on Incomplete/Un	qualified	Г	Part Lost/Mi	ŀ	\neg	Weld
	Cuffs				Contamination		1	ions Incomplete/U	•	Г	Part Moved			Wrong Stock Pulled
	Crushing				Countersink		•	ned/off center		Г	Positioned V	ا Vrong		_
	Heat Tre	at			Cut Too Short		Mislabe			Г	Power Loss/	Surge		Other
	Inspection	on Strip in	Tube		Drawing		Misread	I			•			
	Marks/C	hatter			Drill Holes		Off-set							
		Sequence			Finish		Out of (Calibration						
	Wave/Tu	wist in Tub	ne .	[]	Fit/Function	[Out of	Contioned						

Work Orde		М		*10	8842*						Page 2
Item ID: Revision ID: Item Name:	D2053 Bracket			Accept	*N900	040	100)*	Setup Star	171	S1*
Start Date: Required Date: Reference:	10/29/13 : 10/29/13	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:					
Approvals:		lan:				nte:		I	Run Star Stop	17	R1* R2*
Sequence ID/ Work Center I	D	Operation Description QC8- Inspect parts - seco	ond check	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *.1 2 0 * Brake NC Brake NC		NC BRAKE Memo Form as per	Dwg D2053 using CNC E	0.00 0.00 drake	ć	DAS 30 9-89		16			13/u(
140 *140* QC Quality Control		QC5- Inspect part comp	leteness to step on W/O	0.00 DAS 27 9-89	119			16			

Quality Control

DQA:		Date:				_							,	~AART
QA Closed:		Date:			WORK ORDER NON-	-C(JNFOI	RIMANCE / UI	PDATE	We	ork Order up	odate only		AEROSPACE
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Part N	NO				Scrap			Machining	Small Fab		1	d. Eng. Coor.	\dashv	Quality
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	Bendin	g			Bend	L	Folio/P	rogram			Outside Dim	ensions		Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain	·			Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	it		Temperature/Cure
	Crimp/I	Kink/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Ur	nqualified		Part Lost/Mi	ssing	П'	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/L	Inclear		Part Moved		,	Wrong Stock Pulled
	Crushin				Countersink		Misalig	ned/off center			Positioned V	/rong		
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		ion Strip in	Tube		Drawing		Misread	l	•					
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H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

October-29-13 10:09:15 AM

Item ID:

Revision ID:

D2053

Bracket

Item Name: Start Date:

10/29/13

Start Qty: 5.00 Reg'd Oty: 5.00

Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 10/29/13

Process Plan: _____ Date: QC:

Tooling:

SPC (Y/N):

Set Up/

Accept

Date:

Date:

N900040100

Run

Setup Start

Stop

Sequence ID/ Work Center ID

150

150

HandFinish Hand Finishing Description

Operation

Chemical Conversion Coat per OSI005 4.1

Memo

Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

160 Powdercoat

Powder Coating

Black Sandtex(Ref:4,3.5.7) per QSI005 4.3

OC3- Inspect Part Finish

Memo

Memo

START TIME: OVEN TEMPERATURE FINISH TIME:

0.00

0.00

0.00

DAS

0.00

16. \$ 13-11-20

170 QC

Quality Control

27 9-89

16

DQA:		 	Date:			WORK ORDER NON-CONFORMANCE / UPDATE							DART
QA Closed:			Date:			WORK ORDER NON-	-C(JNFOI	RIVIAINCE / U		Vork Order up	odate only	AEROSPACE
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Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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Root					Desc	ription of work order update		nitial	1	ion	Sign &		
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ŀ	$\overline{}$	Heat Trea	t			Cut Too Short		Mislabe			Power Loss/		Other
	-	Inspection		Tube		Drawing		Misread		L			4 416
	_	Marks/Ch	-			Drill Holes		Off-set					
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108842

Page 4

October-29-13	10:09:15 AM	1			704/			1			
Item ID: Revision ID:	D2053	······································	· · · · · · · · · · · · · · · · · · ·	Accept	*N900	040	100)* s	etup Star	t *N	S1*
Item Name:	Bracket							į	Stop	, *N	S2*
Start Date:	10/29/13	Start Qty: 5.00	*5*		Cust Item I	D:		•	\ \		,
Required Date: Reference:	10/29/13	Req'd Qty: 5.00	*5*		Customer:						
Approvals:	Process Pla	an:		Tooling:		ate:		R	lun Star	^t *N	R1*
E S. T. ■ ■ 					D:	ate:			Stop	` *N	R2*
Sequence ID/ Work Center II	D	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	26
180 Packaging Packaging		Мето		0.00				16X			9-89 13-11-21
190		QC21- Final Inspection	- Work Order Release	0.00					13/1	1/21	#
. *1 		Memo		0.00						. 1	
Quality Control										MF \?	16.11

DQA:		Date:											N	AA PT
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPI		Wor	k Order up	ndate only	_	AEROSPACE
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NCR N	10	<u> </u>			Suspected Unapproved	}		Large Fab	Composite			Supplier		
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Unapproved			<u> </u>			<u> </u>								
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	Centre	Not Conce	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire		F	Part Incorrec	ct [1	Temperature/Cure
	Crimp/	Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unq	ualified	F	Part Lost/Mis	ssing	\	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Un	ıclear]F	Part Moved		\	Wrong Stock Pulled
	Crushi	ng		L	Countersink		Misali	ned/off center]F	Positioned W	Vrong -		
	Heat T	reat			Cut Too Short		Mislabe	eled		F	ower Loss/S	Surge		Other
	Inspec	tion Strip in	1 Tube		Drawing		Misrea	d	_					
	Marks	'Chatter			Drill Holes		Off-set			_		•		
	Turnin	g Sequence	?		Finish		Out of	Calibration						
	Wave/	Twist in Tul	be	[Fit/Function		Out of	Sequence		_				

Page 1

Work Order ID:

108842

Parent Item:

D2053

Parent Item Name:

Bracket

Start Date: 10/29/13

Required Date: 10/29/13

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP D02.03.18Added Rev.B NG(Issue this IPP with part number D2052)

IPP Rev:E now water jet 07-10-25 DD

IPP Rev:F 08-05-14 chg to revC as per ECN1171 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.090 5052-H32 .090 Sheet		Purchased	No			100	sf	58.0600	0.0385	- 0.20263 15	Ac	, /3	-41-2
				Location		Loc Qty	Lo	c Code					
				MAT022		58.06							
				1186	541	20.26							
				1217	780	13.8						, .1	
				1255	552	24			12	5552 <i>-</i>	\longrightarrow	.64	

DQA:			Date:				DER NON-CONFORMANCE / UPDATE						^∂ART		
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Work	Order up	odate only	\neg	AEROSPACE
						DISPOSITION				AGAINST [DEPA	RTMENT	/PROCESS	Ì	
Work Orde	er: .					S				сГ	_		\4/=+== 1=+ \	\neg	
Dort N	u o					Rework			Skid-tube Machining	Crosstube Small Fab	\dashv	Dro	Water Jet d. Eng. Coor.	\dashv	Engineering Quality
Part N	NO.					Scrap Use-as-is			noforming	Finishing	\dashv		e/Packaging	\dashv	Other
NCR I	No.					Suspected Unapproved		incin	Large Fab	Composite	\dashv	nec/stor	Supplier	\dashv	
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification		QC Inspector
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Handling/Pre	Ш														
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Operator												•	1		
Offset/Setup	Ш														
Process															
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		Cracks				Broken/Damage/Defect	H	Hardwa	ire ·			art Incorrec	- F	_	emperature/Cure
	_	Crimp/Kir	nk/Ripple	/Wave		Burrs	Г	1	ion Incomplete/U	Ingualified	_	art Lost/Mi	-	_	Veld
		Cuffs				Contamination	<u> </u>	1	ions Incomplete/	· · · · · · · · · · · · · · · · · · ·		art Moved	<u> </u>	_	Vrong Stock Pulled
		Crushing				Countersink		4	ned/off center	-		ositioned V	ے Vrong		-
		Heat Trea	ıt			Cut Too Short		Mislabe		Ī	Po	ower Loss/	Surge	\neg c	Other
		Inspectio	n Strip in	Tube		Drawing		Misread	d	_			_		
		Marks/Ch	atter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of :	Sequence						

DART AEROSPACE LTD	Work Order:	108842
	And the second s	and the second
Description: Bracket	Part Number:	D2053
Inspection Dwg: D2053 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

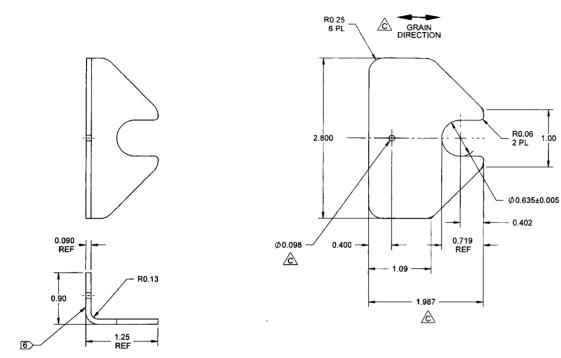
X First Article Prototype

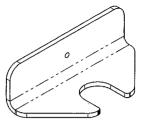
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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			DAS			

	27	
Measured by:	Audited by: 9-89	Prototype Approval:
Date: /3-1/.1	B Date: 13 1/- 18	Date:

Rev	Date	Change	Revised ky	Approved
Α	09.06.01	New Issue	KJ 🛠	<u> </u>

N/A N/A





108842 MLJ 13-10-30 DELEASED

D2053 BRACKET

D2053F FLAT PATTERN

NOTES:
1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.090)
OR
6061-T6 (OR -T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M5061T6S.090)
2) FINISH: CHÉMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2053" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH 7) WEIGHT: 0.04 lbs

С	(ZN A6-	AS 1.979 (ZN I FICATION (ZN I FR COAT MOU RSION COAT I 1); ADD 6061-1 DIRECTION (Z REMOVED; RI	РН	08.04.25			
В	Ø0.635	WAS Ø0.437;	DS	02.03.12			
Α	NEW IS	SUE	ÐS	92,01,12			
REV.			BY	DATE			
DESIGN			DART AEROSPACE LTD				
DRAW	1	E#	HAWKESBURY, ONTARIO, CANADA				
CHECKED		$\mathcal{L}^{\mathcal{L}}$			REV. C		
MFG. APPR.		7/7	□ D2053		SHEET 1 OF 1		
APPROVED		4	TITLE		SCALE		
DE APPR.		-#	BRACKET		NTS		
DATE 08.04.25			COPYRIGHT © 1992 BY DART AEROSPACE LTD THE DOCUMENT REPAINTS AND CONFIDENTIAL AND IS SUPPLED ON THE COPPEDS CONDITION THAT IT IS NOT TO BE USED FOR A NAT MEMOSE OR COMPANIES OR COMMUNICATE TO A NOT OWNER PERSON INTRODIT				

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